



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3294-1

Job Sheet 176811



Part No: D3294-1

Job Qty: 8 ea

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	5/7/18	5/7/18	0.00	0.00	Start Up Waterjet		SC 18/05/03
100	Waterjet	8 pcs	5/7/18	5/7/18	0.00	2.56	Waterjet1		SC 18/05/03
110	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC2 Waterjet-1		SC 18/05/03
120	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC8-2		38
130	Brake NC	8 pcs	5/7/18	5/7/18	0.08	1.10	Brake NC 1		9-89 83
140	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC5		38
150	HandFinish	8 pcs	5/7/18	5/7/18	0.00	0.61	HandFinish1		SA 18-05-08
160	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC7-2		38
170	Small Fab	8 pcs	5/7/18	5/7/18	0.00	1.25	Small Fab-3		DAS 38
180	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC5		38
190	Powdercoat	8 pcs	5/7/18	5/7/18	0.00	0.35	Powdercoat4		BL DAS 15-09
200	QC	8 pcs	5/7/18	5/7/18	0.00	0.00	QC3		1 MAY 10 2018
210	Packaging	8 pcs	5/7/18	5/7/18	0.00	0.00	Packaging3-1		DAS 9-89
220	QC21-SA	8 Ea	5/7/18	5/7/18	0.00	0.00	QC21		21 9-89 MAY 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	14.4000 sf (1.8 ea)	90-Start up Operation	
D3294-5	Doubler	8 Ea (1 ea)	170-Small Fab	5038807
MS20470AD4-5	Rivet, Universal Head	120 Ea (15 ea)	170-Small Fab	M15307750

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.080	14	37	0
170-Small Fab	D3294-5	8	10	0
	MS20470AD4-5	120	3,260	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Un- ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order Deviation

By _____ Supervisor _____

Coordinator _____

Part: D3294-1
 Job No: 176811
 Serial No/Batch: S068256
 Revision: _____
 Inspector: _____

Container No: S068256

DART AEROSPACE
 1270 Aberdeen Street
 Hawthorn, VIC 3122
 Tel: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 06/03/18

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/For ☐	ed Wrong
Design ☐	Operator ☐	Bending ☐	Dimensions
Doc/Data ☐	Offset/Setup ☐	Centre Not C. ☐	nder tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	orrect
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	st/Missing
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

DART AEROSPACE LTD		Work Order: 176 811
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0.130	1		VSC-01	
Ø0.141	+0.005/-0.001	Ø0.144	1			
6.708	+/-0.010	6.709	1			
1.118	+/-0.010	1.120	1			
5.590	+/-0.010	5.595	1			
1.118	+/-0.010	1.119	1			
13.563	+/-0.010	13.565	1			
1.043	+/-0.010	1.045	1			
0.625	+/-0.010	0.623	1			
0.325	+/-0.010	0.328	1			
0.300	+/-0.010	0.302	1			
0.400	+/-0.010	0.403	1			
6.000	+/-0.010	6.001	1			
1.000	+/-0.010	1.001	1			
17.124	+/-0.010	17.125	1			
16.13	+/-0.030	16.14	1			
7.27	+/-0.030	7.28	1			
11.97	+/-0.030	11.98	1			
8.37	+/-0.030	8.376	1			
20.05	+/-0.030	20.05	1			
12.98	+/-0.030	12.99	1			
14.59	+/-0.030	14.60	1			
11.66	+/-0.030	11.666	1			
0.080	+/-0.010	0.080	1			

Measured by: SC	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 18/05/03	Date: MAY 04 2018	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	MA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					